

# Work Order ID 84121

May-03-12 11:26:49 AM

**\*84121\***

Page 1

Item ID: D4617-7 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Clamp Half  
 Start Date: 03/05/2012 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 17/05/2012 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/03 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4617	A

100	Cut blanks as per folio	0.00							
<b>*100*</b>									
Bandsaw	Memo	0.00	PO	12/05/07		12	Ø		
Jeaspa Bandsaw									

110		0.00							
<b>*110*</b>									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FOLIO REV: <u>A</u> DWG REV: <u>A</u> DEBURR			FK 12/05/08		12			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84121

May-03-12 11:26:49 AM

**\*84121\***

Page 3

Item ID: D4617-7 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Clamp Half  
 Start Date: 03/05/2012 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 17/05/2012 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00  0.00				12	0	BL 12-5-9	
160 <b>*160*</b> Packaging Packaging	Identify as per dwg & Stock Location: <b>SPBH</b>  Memo	0.00  0.00				Bx		SP 12-5-9	
170 <b>*170*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						12/5/10 ME 12-05-10	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-03-12 11:26:53 AM

Page 1

Work Order ID: 84121

\*84121\*

Parent Item: D4617-7

\*D4617-7\*

Parent Item Name: Clamp Half

Start Date: 03/05/2012

Required Date: 17/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV: A NEW ISSUE 12-04-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.625X01.50 0		Purchased	No				f	12.9000		1.995789			

\*M6061T6B0 625X01 500\*

6061-T6 Bar .625 x 1.50

\*\*

90

12/05/12

Location

Loc Qty

Loc Code

MAT002

12.9

115111

12.9

2.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

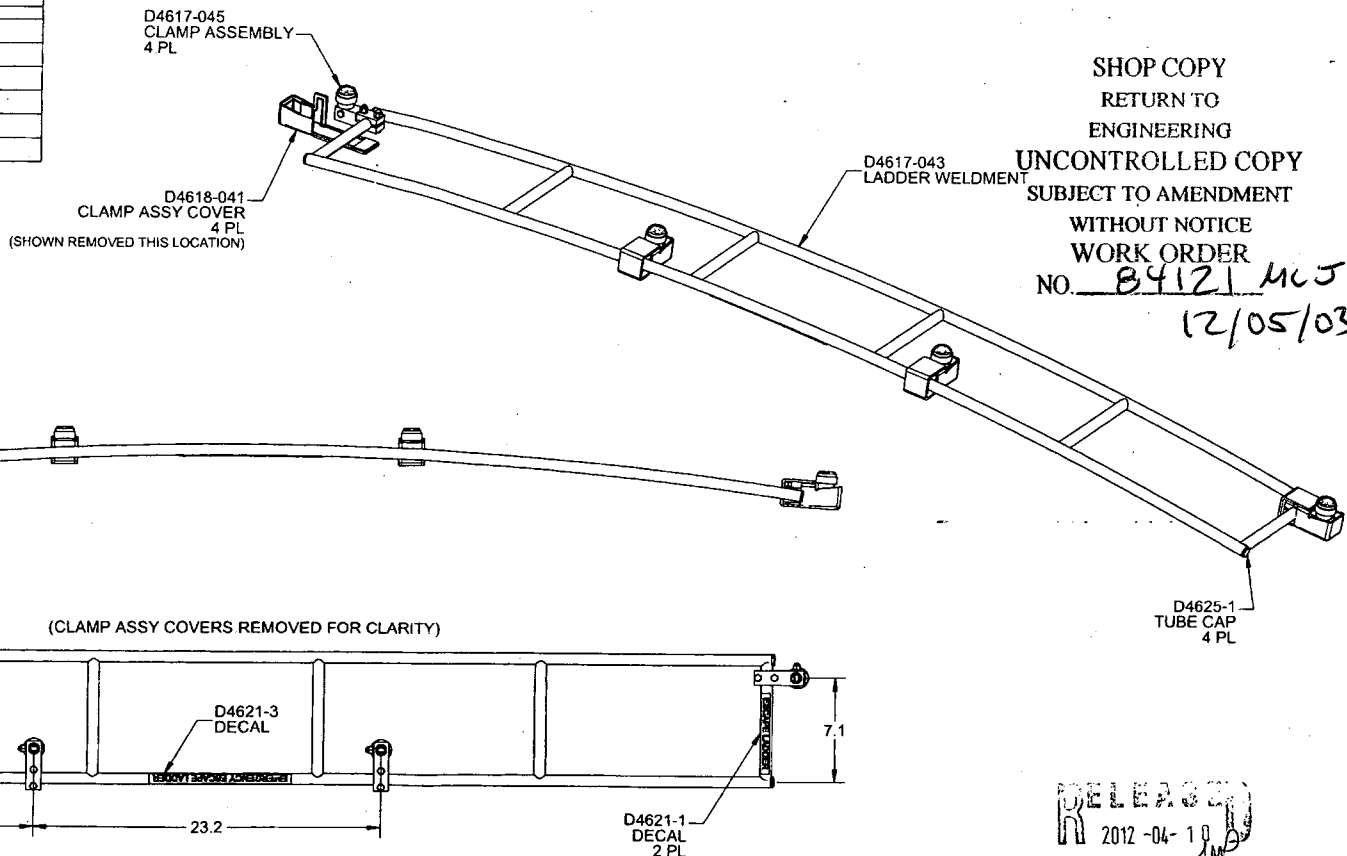
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
	X	D4617-041	EMERGENCY ESCAPE LADDER
1	1	D4617-043	LADDER WELDMENT
2	4	D4617-045	CLAMP ASSY
3	4	D4618-041	CLAMP ASSY COVER
4	2	D4621-1	DECAL
5	1	D4621-3	DECAL
6	4	D4625-1	TUBE CAP



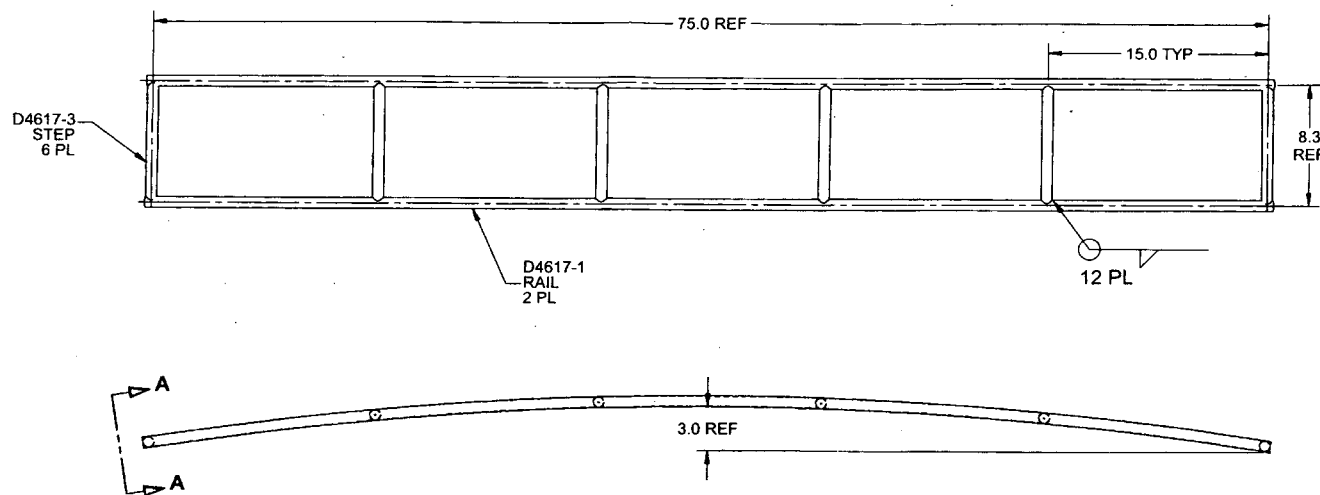
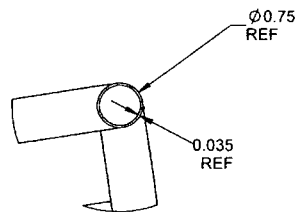
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84121 MJS  
12/05/03

# **D4617-041 EMERGENCY ESCAPE LADDER**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4617-041" AND BATCH NUMBER PER QSI044 6.6
- 7) WEIGHT: 6.46 lbs

A NEW ISSUE		RP	12.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AD	DRAWING NO.	REV. A
MFG. APPR.	AD	D4617	SHEET 1 OF 5
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DE APPR.	AD	EMERGENCY ESCAPE LADDER	NTS
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# **D4617-043 LADDER WELDMENT**

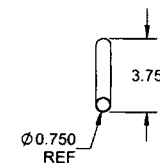
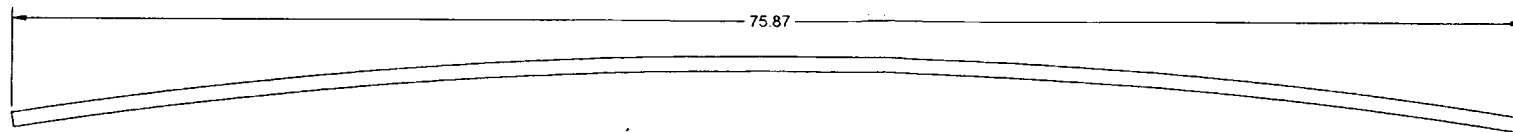
RELEASED  
2012-04-10

## **NOTES:**

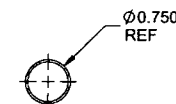
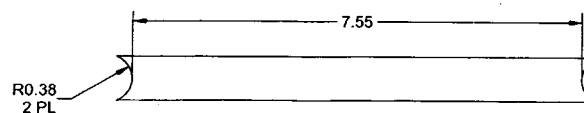
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6
- 7) WEIGHT: 4.5 lbs
- 8) WELDING: PER DART QSI 004

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84121



**D4617-1 RAIL**



**D4617-3 STEP**

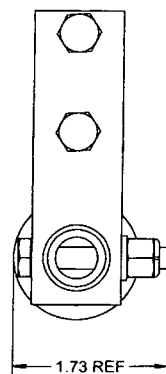
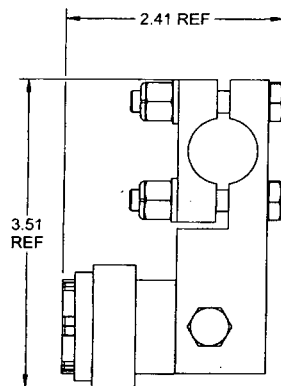
RELEASED  
2012-04-18

**NOTES:**

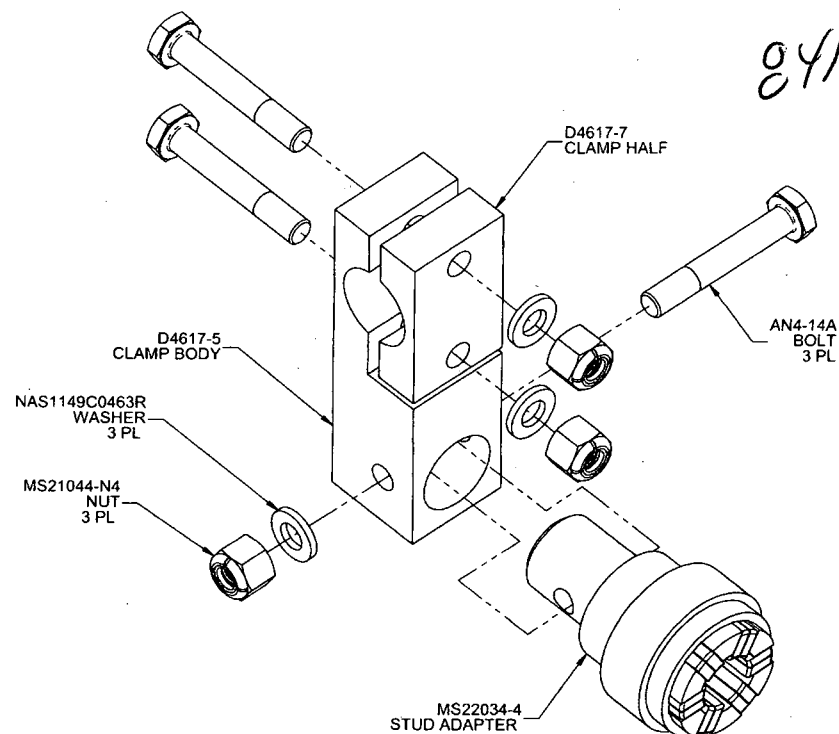
- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T6736  
OR AMS6371, 6360, 6361, 6362, 6373, 6374  
REF DART SPEC M4130NT0.750V.035
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: D4617-1 1.7lbs  
D4617-3 0.17lbs

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MFG. APPR.	[Signature]	SHEET 3 OF 5	
APPROVED	[Signature]	TITLE	SCALE
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ITEM	QTY	P/N	DESCRIPTION
	X	D4617-045	CLAMP ASSEMBLY
1	1	D4617-5	CLAMP BODY
2	1	D4617-7	CLAMP HALF
3	3	AN4-14A	BOLT
4	3	MS21044-N4	NUT
5	1	MS22034-4	STUD ADAPTER
6	3	NAS1149C0463R	WASHER



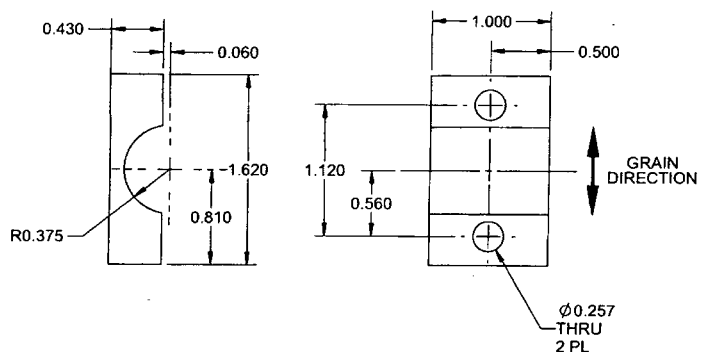
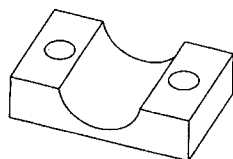
**D4617-045 CLAMP ASSY**



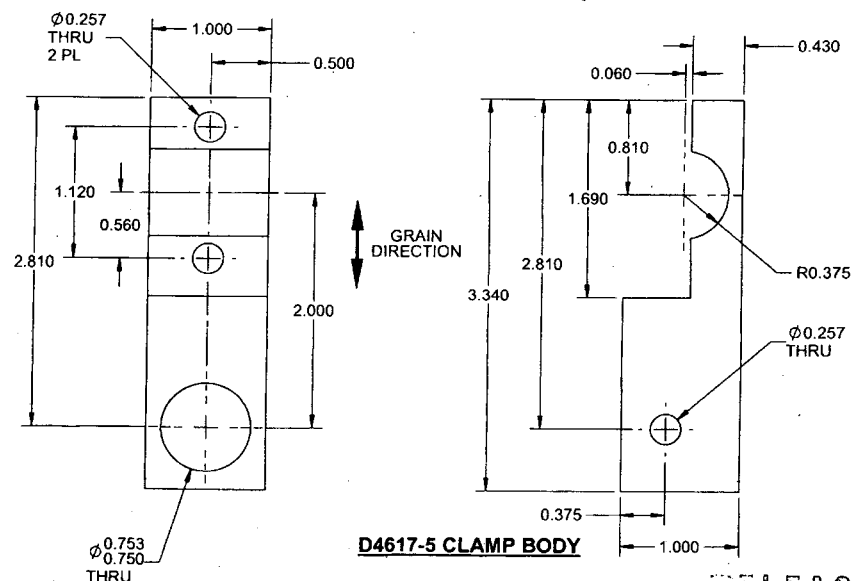
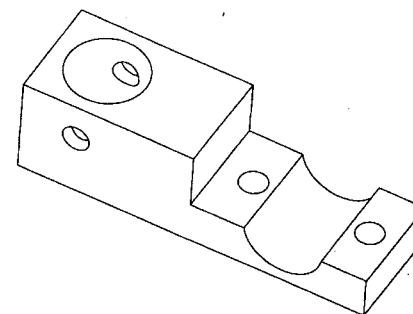
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: 0.5 lbs

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**D4617-7 CLAMP HALF**



**D4617-5 CLAMP BODY**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR  
AMS 4117/4128/4115/4116 OR QQ-A-200/8  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: D4617-5 0.17 lbs  
D4617-7 0.05 lbs
- 8) POSSIBLE SUPPLIER: D4617-5: EAGLE P/N 212-110-06  
D4617-7: EAGLE P/N 212-110-07

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2012-04-10

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MFG. APPR.		<b>D4617</b>	SHEET 5 OF 5
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